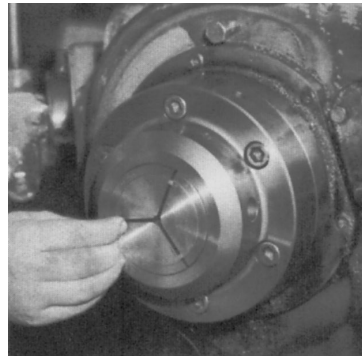


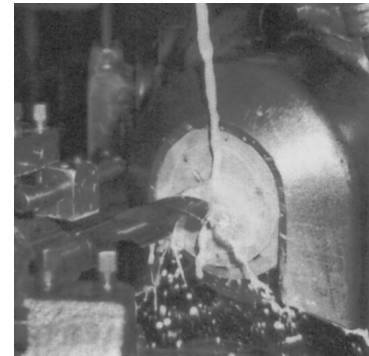
— Install the Pads —

Hardinge® Emergency Pads for Turret Lathe Collets

Even with the best of planning, emergencies arise when you may require a stepped, odd size or special-shape collet pad. It is a good idea to carry a few Emergency Collet Pads in your tool crib so they are close at hand when an emergency arises. The soft face and $\frac{5}{16}$ " order hole permit rapid drilling, boring or stepping out to the exact size required. Pins are supplied to hold the pad in the normal closed position for precision machining.



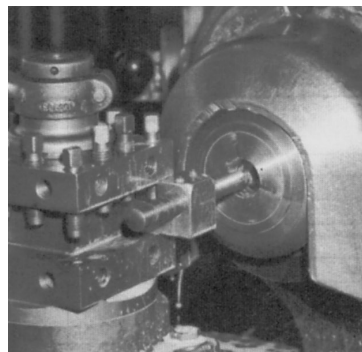
— Insert Pins —



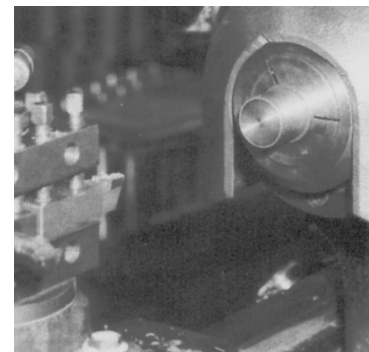
— Drill —

Boring the Pads to size

Clean the pad seat and install the pads in a clockwise letter sequence (A,B,C). Insert the pins, drill, rough and finish bore as required to the exact part size. Remove pins and insert the part.



— Rough & Finish Bore —



— Remove Pins and Insert Part —

Machine	Machine Number	Master Collet Part Number	No. of Splits	Collet Pad Part Number
Gisholt	No.3	3Y-7112A	4	5753-1410
Gisholt	No.3L	13X-6561	4	MP-2622-E
Gisholt	No.4: 2"	1129-E	3	5841-1410
Gisholt	No.4	4Y-7112A	4	MP-1562-E
Gisholt	No.5 Or 1L	5Y-7112	4	MP-1563-E
Jones & Lamson	No.3	10463	3	MP-2070-E
Jones & Lamson	No.4	11709	3	5807-1410
Jones & Lamson	No.5: 2 $\frac{1}{2}$ "	10464	3	5723-0000
Jones & Lamson	No.5: 3"	15246	3	5723-1410
Warner & Swasey	No.3 & No.4: 1 $\frac{1}{2}$ "	461-E	3	5837-1410
Warner & Swasey	No.4: 2"	1129-E	3	5841-1410
Warner & Swasey	No.5 or 1A	471-E	3	5845-1400
Warner & Swasey	No.5: 2 $\frac{1}{4}$ ", No.6: NS	357	6	MP-1456-E